

Work Order ID 63249

Tuesday, October 26, 2010 11:54:43 AM



Page 1

Item ID: D2654-3

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 10/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

M

Date: *10/10/26* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2654 | Rev E1 |

100 0.00



Skidtubes

Skidtubes

Memo 0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends

DP

10-10-26

110 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo 0.00

Quality Control

1 0 BE10-10-26

120 0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo 0.00

Hand Finishing

DP

10-10-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 63249

Tuesday, October 26, 2010 11:54:43 AM



Page 2

Item ID: D2654-3

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 10/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE 10/10/27

140

Identify as per dwg & Stock Location: LL

0.00



Packaging

Memo

0.00

Packaging

1 0 BE 10/10/27

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/27
MF
10-10-27

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 11:54:47 AM

Page 1

Work Order ID: 63249



Parent Item: D2654-3



Parent Item Name: Web



Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|---|-------------|--------------|---------------|----------------|--------|
| D2600-5-108  | | Manufactured | No | | | 100 | Each | 141.0000 | 1 | 1 | | | |
| Extrusion 'I Beam' thin | | | | | | | |  | | | | | |

Location

LG

47814

Loc Qty

141

141

Loc Code

①



10-10-26

| W/O: | | WORK ORDER CHANGES | | | | | |
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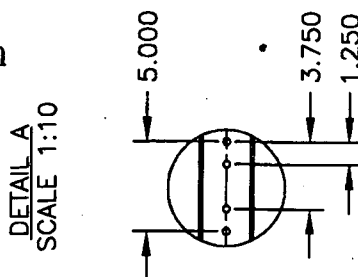
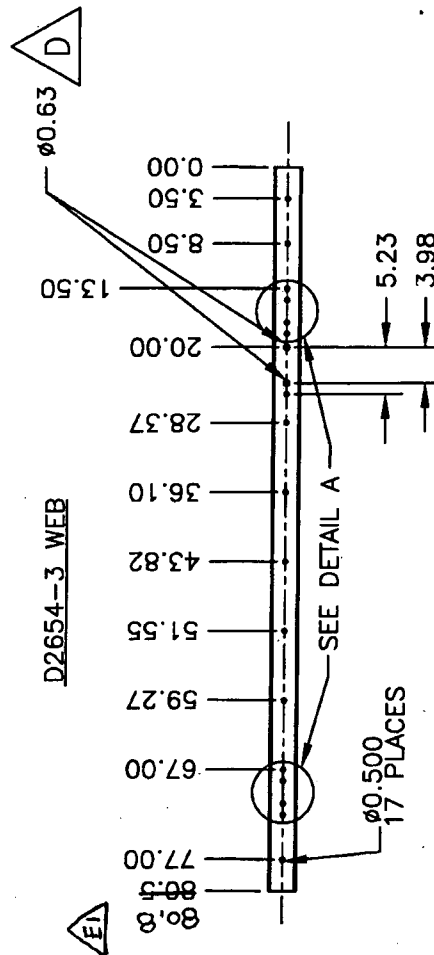
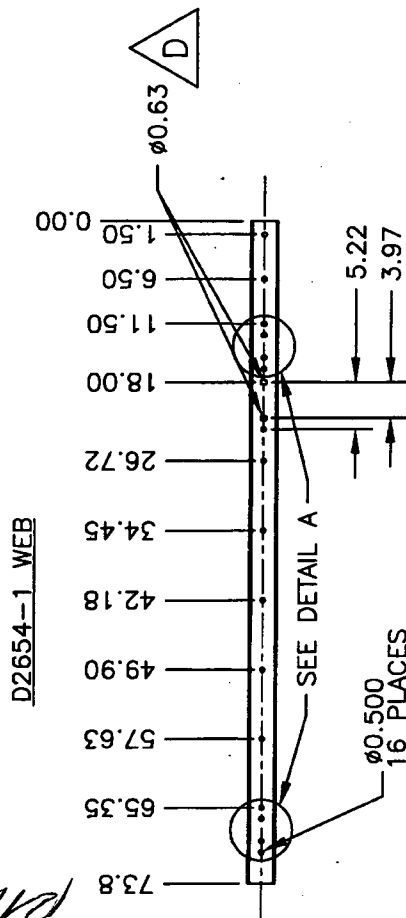
NOTE: Date & initial all entries

DART
DEO ATTACHED



| | | | | | |
|---------|---------------|------------------------------------|----|--|------------------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED | # | APPROVED | # | DRAWING NO. D2654 | REV. E SHEET 1 OF 2 |
| DATE | 04.05.26 | | | TITLE WEB | SCALE 1:20 |
| A | 97.03.25 | NEW ISSUE | | | |
| B | 97.06.26 | ALTER HOLE PATRN., 0.500 WAS 0.438 | | | |
| C | 97.10.29 | CHANGED HOLE PATTERN | | | |
| D | 98.01.15 | GHW HOLES CHANGED TO $\phi 0.63$ | | | |
| E | 04.05.26 | CHANGE LENGTHS, REFORMAT | | | |
| E1 | CP # 04.08.24 | PER TOOLING; 80.8 WAS 80.5 | | | |

RELEASED
04.06.22



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

DART

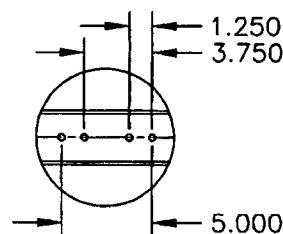


| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | REV. E |
|----------------------------|-----------------------------|--------------------------|--------------|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2654 | SHEET 2 OF 2 |
| DATE 04.05.26 | TITLE WEB | SCALE 1:20 | |

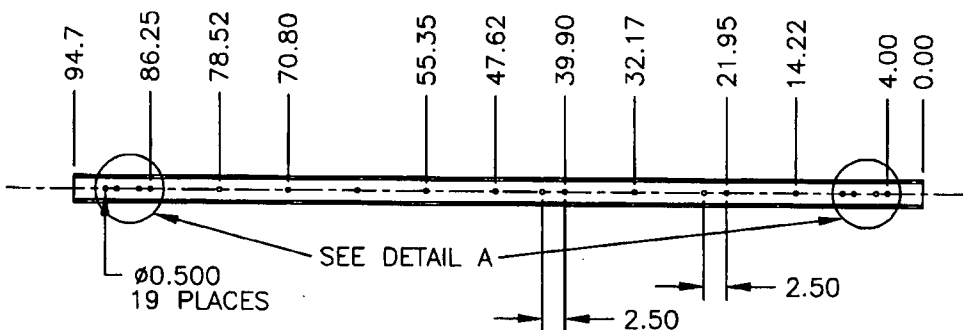
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04.06.22

DEATTACHED

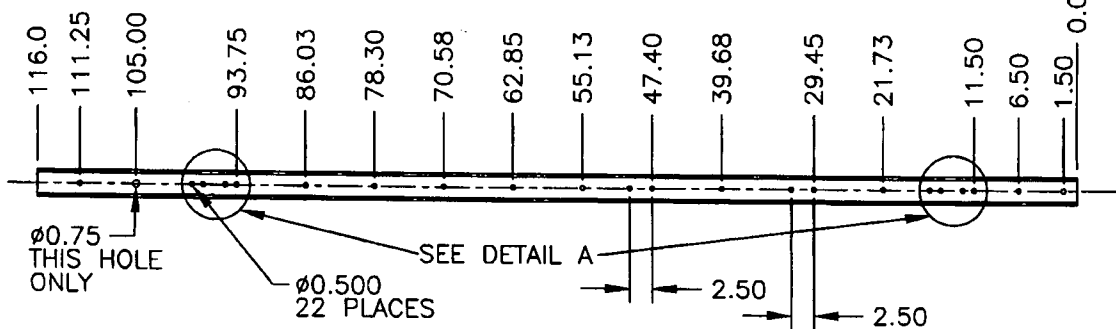
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/6 63249

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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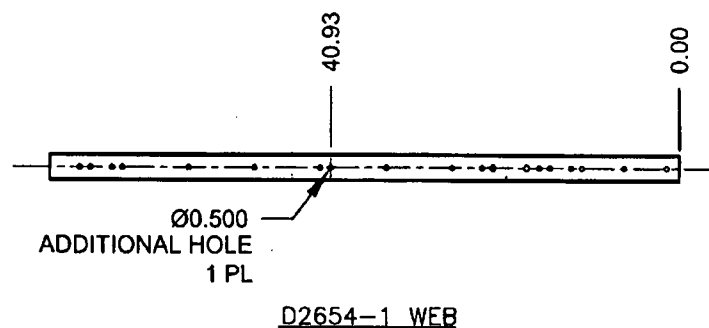
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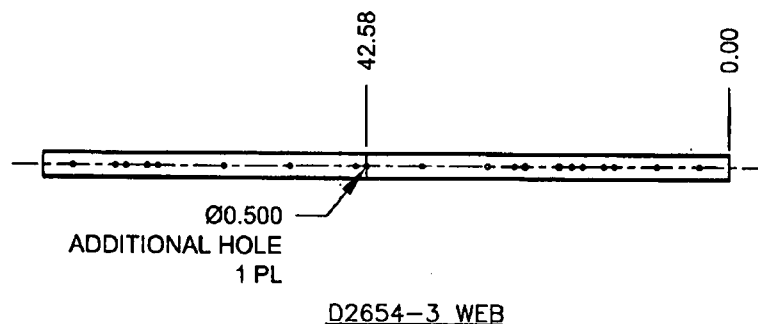
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|----------------------|----------------------|------------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D2654 | TITLE WEB | REV. E1 | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D2654-E-2 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>CP</i> | CHECKED <i>PH</i> | MFG. APPR. <i>E</i> | APPROVED <i>MP</i> | | DE APPR. <i>MP</i> | | |
| DATE 09.03.11 | DATE 09.03.11 | DATE 09.04.03 | DATE 09.04.03 | | DATE 09.04.03 | | |

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MP*



u603249



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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